

Recess Tool with Cyl. Grinding Ø8 Z1

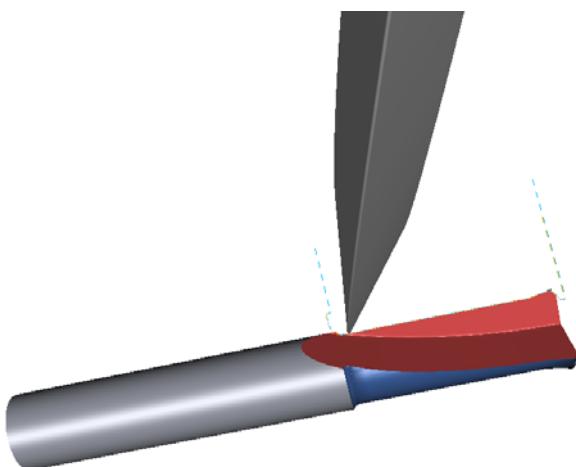
A17-010

The A02-001 Application allows to execute a DXF-profile grinding process in a cylindrical grinding mode - typically used for the production of ID turinng tools. Designed as shown in the pictures the tool can be resharpened over 120°.



1. Cycletime for Production

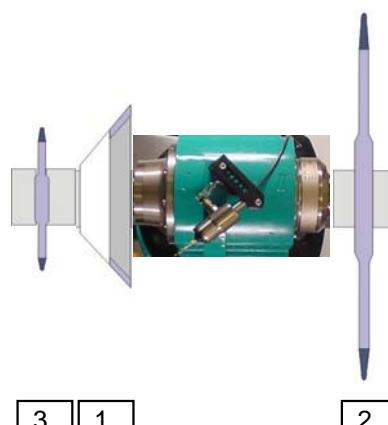
Workpiece:	Ø 8mm, Z1, L=25 mm Material CARBIDE		
Operations	Probe	Gashing	Prf Pgnd
Feed [mm/Min]	2000	5	4
Power [kW]		2	4
Cutting speed [m/s]		22	24
Used wheels		1	2
Grinding time [s]	20	120	411
Total cycle time	25 Min 10		



The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	12V9 Ø125 D64
2	14EE1 Ø200 D64
3	14EE1 Ø40 D64



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG

Coolant: Synthetic Oil, pressure 6 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories:

Responsible engineer: LLU, 02.04.2013

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Deutschland, Italia, United States, China